

Date: Friday, 30/11/2007 10:03:01 AM
User: Linda Lacelle

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36078

Part Number: D206628013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2845

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2845 ARM B36089

CU 8/1/8 (2)

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6038 f(s)/Unit Total : 1.2075 f(s)

Pick:

Qty Part # Description Batch
1 D2856-400 6.9" Abrasion Strip 35900

AS

8.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.0920 f(s)

Pick:

Qty Part # Description Batch
1 D2856-400 6.25" Abrasion Strip 35900

AS

9.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3394-041 LUG ASS,Y B30997

AS

(x2)

10.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3394-043 LUG ASS,Y B34489 x2 B34917 x2

AS

(x2)

11.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN3C4A Bolt M10 5559

AS

8/1/7

(x2)

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Part Number: D206628013

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 AN4C11A bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C11A Bolt M19600

AS

(x2)

13.0 AN4C12A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C12A Bolt M105979

AS

(x2)

14.0 AN4C15A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C15A Bolt M103915

AS

(x2)

15.0 AN960C10 WASHER



Comment: Qty.: 2.0000 EACH(s)/Unit Total : 4.0000 EACH(s)

Pick:

Qty Part Number Description Batch
2 AN960C10 Washer M106302

AS

(x2)

16.0 AN960JD416L Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch
24 AN960JD416L Washer M105728

old Batch

M106303(x8)

AS

(x2)

17.0 NAS1515H4L WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch
24 NAS1515H4L Washer M105728

AS 8/1/7

(x2)

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Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36078

Part Number: D206628013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	MS210434	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS21043-4	Nut (or MS21042-4)	M106042

AS

(12)

19.0	NAS1515H3	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3	Washer	M106043

AS 08/01/07

(2)

20.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/08 (2)

21.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-013

Location:

PPP Rev: E

8/1/8 50 (2x)

22.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/01/08 (2)

Job Completion

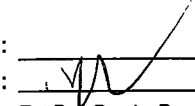
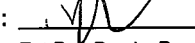


u 08.01.09

628-013

Date: Friday, 30/11/2007 10:03:12 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B FLOAT STEP ASSY, LH
Job Number : 36078A	
Estimate Number : 11662	
P.O. Number :	Part Number : D2841041
This Issue : 30/11/2007 S.O. No. :	Drawing Number : D2841 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run :	Material :
Written By : 	Due Date : 23/12/2007 Qty: 2 Um: Each
Checked & Approved By : 	
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	834694 835618

Check Material for any Dents or Defects

07.12.06
07.12.03

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2841-1 using D2622 extrusion as per Dwg D2841

2-Drill extrusion per drawing D2841 using Jig DT 8265

3-Deburr and bevel ends for welding

06
07.12.03 2
06
07.12.03 2
06
07.12.03 2

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	834485

06
07.12.03 2

Date: Friday, 30/11/2007 10:03:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, LH

Job Number: 36078A

Part Number: D2841041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D34641

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
1	D3464-1	Plate	325425

06
16 07.12.03

2

5.0

D34643

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-3	Plate	325426

06
16 07.12.03

2

6.0

D34645

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-5	Plate	325427

06
16 07.12.03

2

7.0

D34647

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-7	Plate	325428

06
16 07.12.03

2

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Grind end only, then grind.

1-Weld end cap (1- END ONLY) and lugs as per Dwg D2841
using Jig DT 8267 followed by DT 8268

A/R AL ROD Batch: M105058
M105844

2-Grind end cap welds flush

06
16 07.12.03

07
16 07.12.04

07
16 07.12.07

2

2

2

Q M

07.12.31

2

Date: Friday, 30/11/2007 10:03:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, LH

Job Number: 36078A

Part Number: D2841041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

~~DO NOT USE~~ QCA

WELD INSPECTION



P70

Comment: WELD INSPECTION

PD 07-12-10 (2)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 07.12.10

(3)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.12.11 2

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

07.12.11 2

2-Weld Remaining end cap as per Dwg D2841

using jig DT 8267 followed by DT 8268

A/R AL ROD Batch: M105058

07.12.11 2

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/01/02 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/02 (2)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine & Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Touch up Alodine - FR 08/01/02 (2)

PRESSURE WASH BR 08-01-03 (2)

FR 08/01/04 (2)

Date: Friday, 30/11/2007 10:03:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, LH

Job Number: 36078A

Part Number: D2841041

Job Number:



P70-7

Seq. #:

Machine Or Operation:

Description :

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-04

(2)

17.0

NAS1329C3KB130

insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

4

NAS1329C3KB130 Insert

m105385

FEL

18.0

MS27039C107

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

MS27039C1-07

Screw

m105426

FEL

19.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4

NAS1515H3L

WASHER

m105446

FEL

20.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

AN960C10L

WASHER

m106574

FEL

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: m106332

m-k

FEL 08/01/04
08/01/05 (2X)

(2)

Date: Friday, 30/11/2007 10:03:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, LH

Job Number: 36078A

Part Number: D2841041

(P78) →

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

58/01/07 (x2)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

APP 36078 8/1/8 50 (2x)

24.0

QC21

FINAL INSPECTION/W/O RELEASE


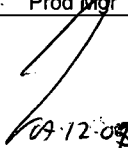
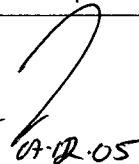


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

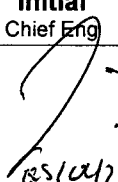
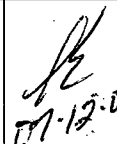
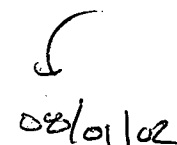

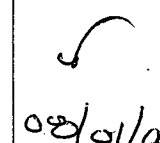


LU 08-01-09

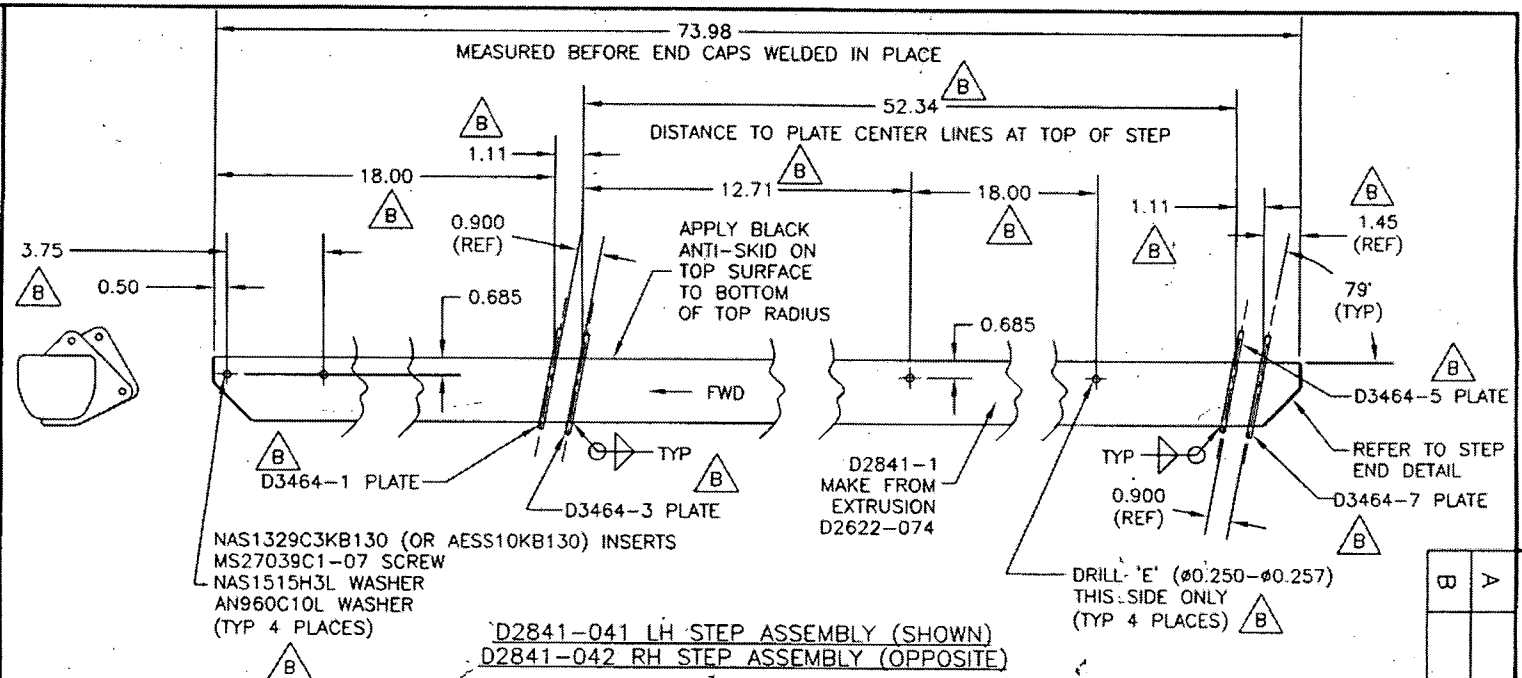
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-12-05	9.0	QC9 required, for weld inspection. Perm change to add "QC9"		07/12/05		 07-12-05	 07-12-05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-05	9.0	Upon weld inspection, cracks were visible on a visual inspection. 2 steps cracked & scrap. R.C: To much heat during welding, and is apparent on the inside of the step	 08/01/02	Scrap & destroy Qty 2. replace Qty 2 B <u>35618</u>	 07-12-05	 08/01/02	 08/01/02	 08/01/02

NOTE: Date & initial all entries



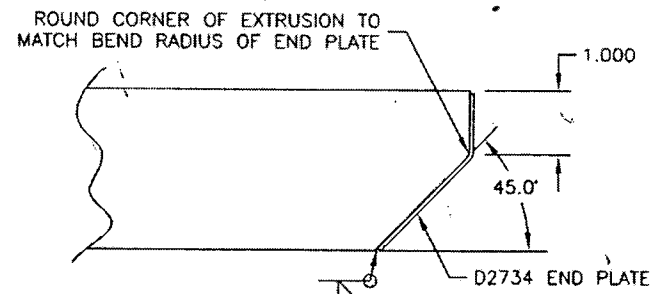
D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D2841-041	LH STEP ASSEMBLY
		D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

D2841-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
05/11/14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.21		2068 FLOAT STEP ASSEMBLY	NIS
A	98.10.14	NEW ISSUE	
B	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7	

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